Work Order ID 60515

Tuesday, July 13, 2010 11:07:22 AM



Page 1

Item ID:

D3955-5

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name: Plate

Required Date: 7/20/2010

7/13/2010

Start Qty: 8.00 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: QC:

Date: 12/2 Tooling:

Date:

0.00

0.00

Date:

Date:

Run

Start



Stop

Qty

Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ Run Hours

SPC (Y/N):

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Draw Nbr

D3955 Α

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3955

Dwg Rev: Prog Rev:

QC2- Inspect parts off machine FAI/FAIB

2-Deburr if necessary

110

QC

Memo

0.00

0.00

Quality Control

W/O:			V	ORK ORDER CHANG	iES			1		
DATE	STEP	PRO	CEDURE CH	ANGE	Ву		Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:						ł	Date:	
	R	esolution:							Date: _	
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng		gn & ate	Verifica Section		Approval Chief Eng	Approval QC Inspector
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Work Order ID 60515

Tuesday, July 13, 2010 11:07:22 AM



Page 2

Item ID:

D3955-5

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Plate

Required Date: 7/20/2010

7/13/2010

QC:

Start Oty: 8.00

Req'd Oty: 8.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Date:

Run

Start Stop

Stop



SPC (Y/N):

Tool # Plan

Code

Accept Oty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

120

Quality Control

Memo

QC8- Inspect parts - second check

Set Up/ Run Hours

0.00

S 10(0+114

Tool ID

130

Packaging

Packaging

Identify as per dwg & Stock Location: /32

Memo

0.00

0.00

140

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qу	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	_ NCR:	Yes N	o DQA :		_ Date: _	
	R	esolution:	Dispositi	on:	QA: I	V/C Clos	sed:		Date: _	
NCR:		\	WORK OR	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	124: -1		tion B	Cian 9	Verifica	on	Approval	Approval
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Picklist Print

Tuesday, July 13, 2010 11:07:25 AM

Work Order ID: 60515

Parent Item:

D3955-5

Parent Item Name: Plate



Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	51.5039	0.3545	2.985263			

304/316 Sheet .063

 Location
 Loc Oty
 Loc Code

 MAT
 51.50389474

 111323
 0

 114799
 51.5038947

M. 10.07.14

Dart Aerospace Ltd	Da	rt /	4erc	spa	ace	Ltd
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DATE	STEP	Description of NC		Corrective Action Section		Verifica	ion	Approval	Approval
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DART AEROSPACE LTD	Work Order:	603/5
Description: Plate	Part Number:	D3955-5
Inspection Dwg: D3955 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

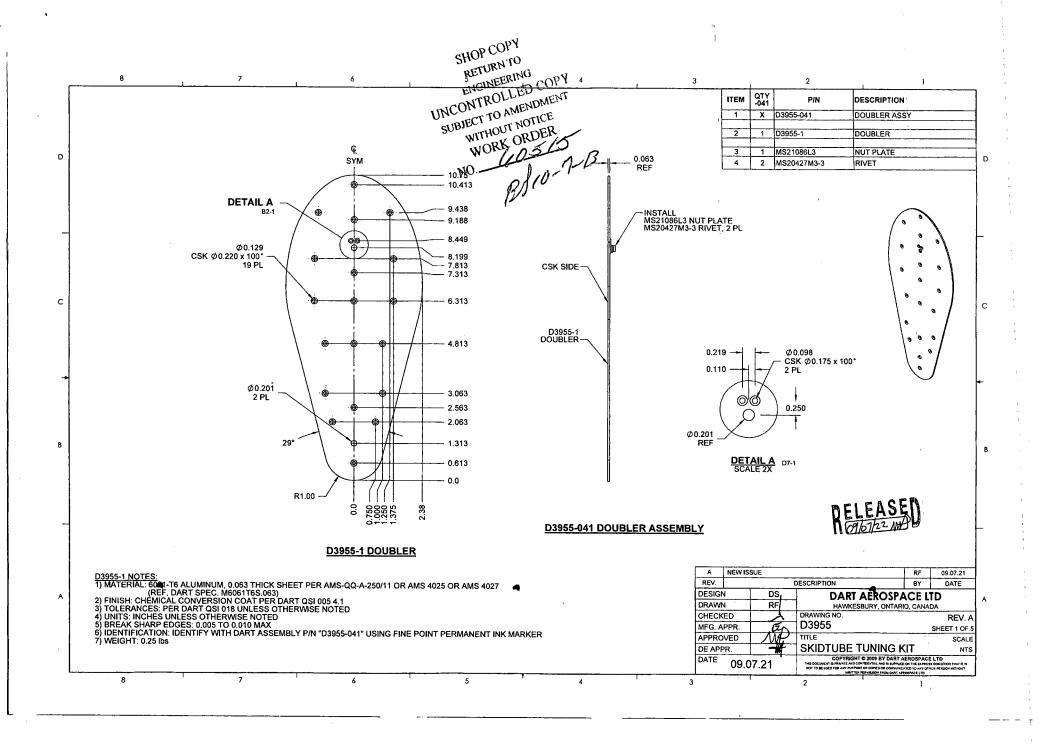
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
Ø0.201	+0.005/-0.001	0.202	/		VerN		
1.31	+/-0.030	1.31	V		VIN		
10.75	+/-0.030	10.75	V		MT		
6.886	+/-0.010	6.886	V		MT	•	
4.75	+/-0.030	4.76	V		Very	_	
0.063	+/-0.010	0.059	V		Very		•
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sured by:	M M	Audited by:			Prototype A	nroval:	N/A

Measured by:	M.M	Audited by:	Prototype Approval:	N/A
Date:	10.07.14	Date: 10(07/4	Date:	N/A

Rev	Date	Change	Revis	se¢	by	Appr	oved
Α	09.07.29	New Issue	KJ	W	7	M	
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Dart Ae	rospace L	td						
W/O:			WC	RK ORDER CHANG	GES			
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Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
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	T	Description of NC		Corrective Action Sec	tion B	Verification	Approval	Approva
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Ę SYM **— 10.75** APPLY ANTI-SKID ON ONE SIDE ONLY 8.199 29° - 1.313 Ø0.201 2 PL 0.0 R1.00 2.38 **D3955-3 COVER PLATE**

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs

DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3955 MFG. APPR. SHEET 2 OF 5 TITLE APPROVED SCALE SKIDTUBE TUNING KIT DE APPR. NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	۱& _{Sect}	ion C	Chief Eng	QC Inspector
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Ø0.201 2 PL R1.00 -€ SYM 4.75 29° 1.31 6.886 10.75

D3955-X PLATE

General Table								
P/N	T (in)	T (GA)	WEIGHT (lbs)					
D3955-5	0.060	16	0.64					
D3955-7	0.120	11	1.28					

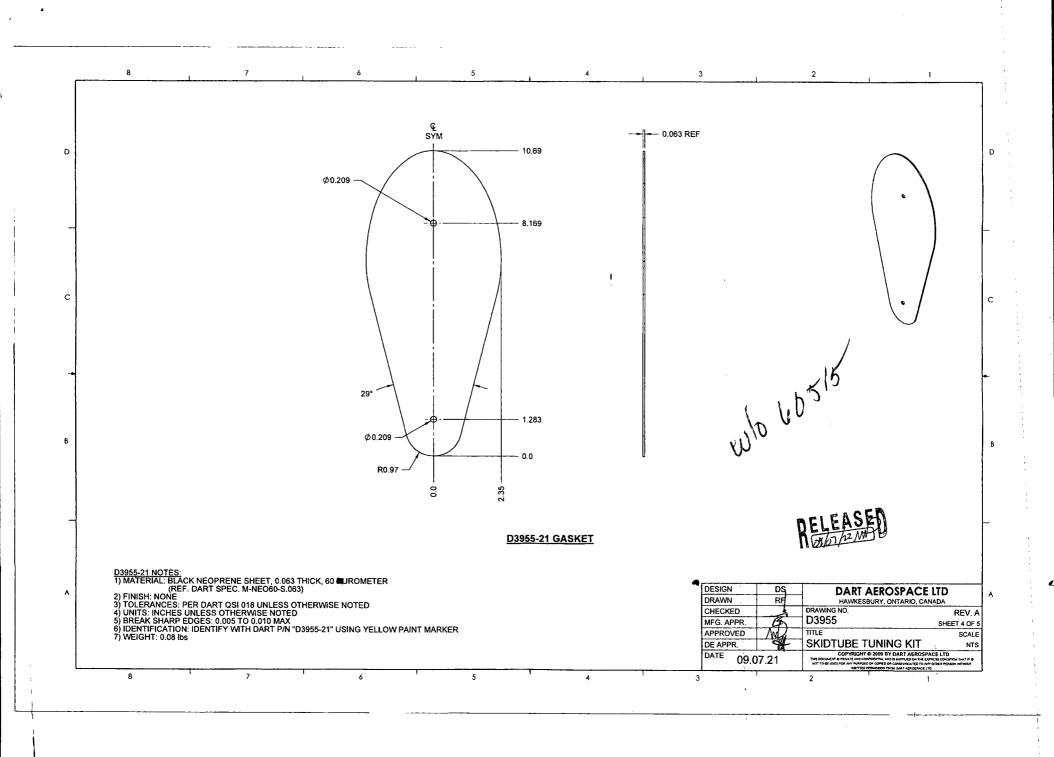
who 60515

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'T'GA)
2) FINISH NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: SEE TABLE

DART AEROSPACE LTD DESIGN DS. DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3955 MFG. APPR. SHEET 3 OF 5 APPROVED TITLE SCALE SKIDTUBE TUNING KIT DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
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W/O:			W	ORK ORDER CHANG	ES				
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval** Approval STEP DATE PROCEDURE CHANGE By Date Qtv Chief Eng / Prod Mgr QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: _ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR:

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tion	Approval Chief Eng	Approval QC Inspector

8 € SYM - 0.040 REF -- 11.13 10.600 D 9.625 8.500 8.000 Ø0.098 7.500 19 PL 6.500 5.000 3.250 29° - 2.750 2.250 1.500 Ø0.129 0.800 2 PL 0.0 R1.19 D3955-23 TEMPLATE NOTES:
1) MATERIAL: 8061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER DESIGN DS, DART AEROSPACE LTD Α DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3955 MFG. APPR SHEET 5 OF 5 APPROVED TITLE SCALE SKIDTUBE TUNING KIT DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
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		Description of NC		Corrective Action Section B		Verificatio	n Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
								